

Work Order ID 57250

March 31, 2010 10:01:18 AM

PRELIMINARY
ISSUE

Page 1

Item ID: D4091-1

Accept



Setup Start



Revision ID:

Stop



Item Name: Mounting Lug

Start Date: 31/03/2010 Start Qty: 6.00



Start



Required Date: 01/04/2010 Req'd Qty: 6.00



Cust Item ID:

Customer:

Reference:

JRW 10-03-31

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D4091

PAT A 10/03/20

POSITIVE
RECALL

0.00

0.00

DJP 10/03/31

6 Ø

100



Bandsaw

Memo

Jeaspa Bandsaw

CUT BLANK 1.450" LONG

110



HAAS I

HAAS CNC vertical machine #1

Memo

0.00

MACHINE AS PER FOLIO FA920 AND DWG
FOLIO REV: AA
DWG REV: A

DJP 10/03/31

6 Ø

DEBURR

Work Order ID 57250

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Page 2

Item ID: D4091-I

Accept



Setup Start



Revision ID:

Item Name: Mounting Lug

Stop



Start Date: 31/03/2010 Start Qty: 6.00



Cust Item ID:

Required Date: 01/04/2010 Req'd Qty: 6.00



Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
Description

120



QC

Quality Control

Memo

Set Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

0.00

10/03/31

6

0.00

130



QC

Quality Control

QC8- Inspect parts - second check

QC 10/04/10 to perform on 17

Memo

0.00

10/03/31

6

0.00

QC APPROVAL

10.04.21

140



HandFinish

Hand Finishing

Chemical Conversion Coat per QSI005 4.1

Memo

10-4-1

0.00

 POSITIVE RECALL
 EFFECTIVE _____ AUTH _____
 RELEASED _____ DATE _____

Work Order ID 57250

March 31, 2010 10:01:18 AM



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Accept



Setup Start



Revision ID:

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Item Name: Mounting Lug

Start Date: 31/03/2010 Start Qty: 6.00



Cust Item ID:

Required Date: 01/04/2010 Req'd Qty: 6.00



Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

150



Powdercoat

Powder Coating

Operation
DescriptionM113170.
White Gloss(Ref:4.3.5.1) per QSI005 4.3-AlumSTART 8:00
Memo
COAT. 300°
FINISH 8:50Set Up/
Run Hours

0.00

Draw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

BR 10-4-1

6 0.

160



QC

Quality Control

QC3- Inspect Part Finish

0.00

Memo

0.00

QC APPROVAL

170



Packaging

Packaging

Identify as per dwg & Stock Location

0.00

Memo

0.00

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Page 4

Item ID: D4091-1

Accept



Setup Start



Revision ID:

Item Name: Mounting Lug

Stop



Start Date: 31/03/2010 Start Qty: 6.00



Cust Item ID:

Required Date: 01/04/2010 Req'd Qty: 6.00



Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

180



QC

Quality Control

Operation
Description

QC21- Final Inspection - Work Order Release

Memo

Set Up/
Run Hours

0.00

Draw
Number

Rev.

Draw
Number

Rev.

Plan
Code

Auth

Plan
Code

Auth

Accept
Qty

U

Accept
Qty

U

Reject
Qty

10/06/02

Reject
Qty

10/06/02

Reject
Number

JG

Reject
Number

JG

Insp.
Stamp

10/06/02

Insp.
Stamp

10/06/02

POSITIVE RECALL
 EFFECTIVE 10-03-31 AUTH U
 RELEASED JG DATE 10-04-21

W 06/02
10/06/02

Picklist Print

March 31, 2010 10:01:18 AM

Page 1

Work Order ID: 57250



Parent Item: D4091-1



Parent Item Name: Mounting Lug

Start Date: 31/03/2010

Required Date: 01/04/2010

Comments: IPP REV :A NEW ISSUE 10-03-31 JLM VERIFIED BY:EC

Start Qty: 6.00

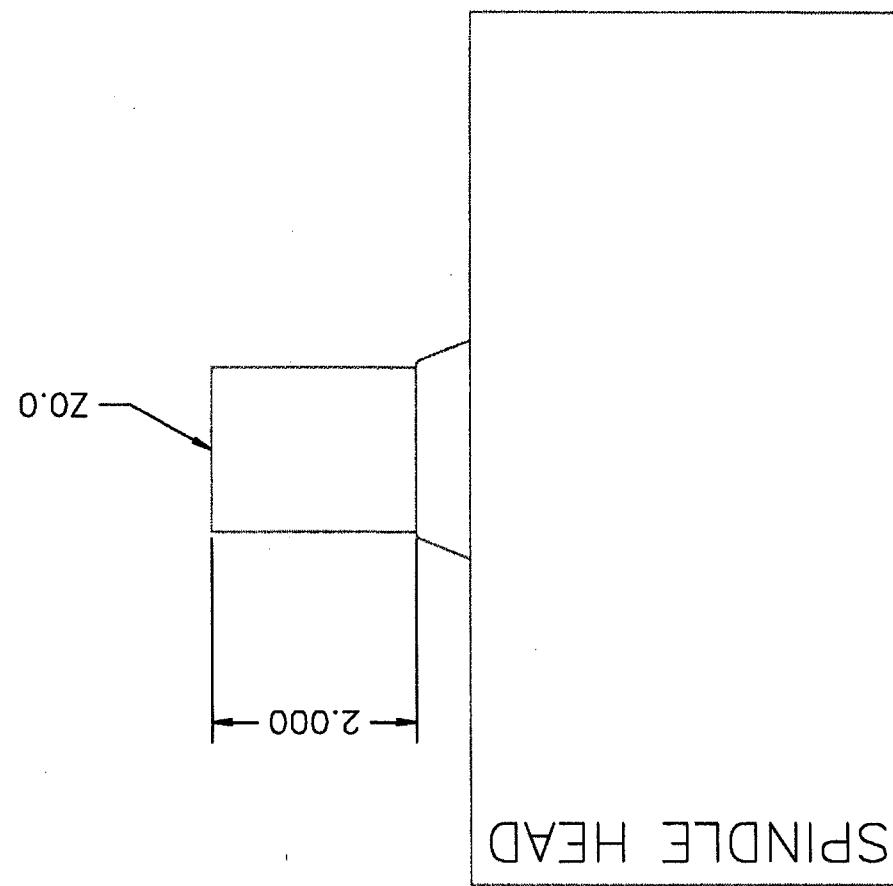
Required Qty: 6.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D2423 		Manufactured	No			100	f	556.0417	0.7901 			

Lug Extrusion

<u>Warehouse</u> <u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
Main Warehouse		
MAT06	556.0417432	
43722	173.462806	
44529	5.7731	
45800	376.805837	

0.7901(f) 
10/03/31



D3317-11-3 WASHER

DART AEROSPACE LTD	Work Order:	52250
Description: Mounting Lug	Part Number:	54091-1
Inspection Dwg:	Rev:	PA1

Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

First Article Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
R0.050	± 0.020	0.05	✓			TYP Around Pad
4.45	± 0.030	4.452	✓			
1.38	± 0.030	1.377	✓			
0.27	± 0.030	0.264	✓			REF
R1.20	± 0.030	1.20	✓			
0.735	± 0.010	0.726	✓			REF
0.293	± 0.010	0.289	✓			
3.700	± 0.010	3.699				
$\phi 0.257$	$+0.006/-0.001$	0.259	✓			4PL
R0.34	± 0.030	0.34	✓			
0.375	± 0.010	0.375	✓			
0.625	± 0.010	0.625	✓			
2.310	± 0.010	2.314	✓			REF
1.91	± 0.030	1.913	✓			
R0.630	± 0.030	0.63	✓			2PL
35°	$\pm 1/2^{\circ}$	35°	✓			TYP
$\phi 0.257$	$+0.006/-0.001$	0.259	✓			
R0.400	± 0.010	0.400	✓			
0.688	± 0.010	0.689	✓			

Measured by:	DJP	Audited by:	JL	Prototype Approval:	N/A
Date:	10/03/31	Date:	10/03/31	Date:	N/A

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	

D

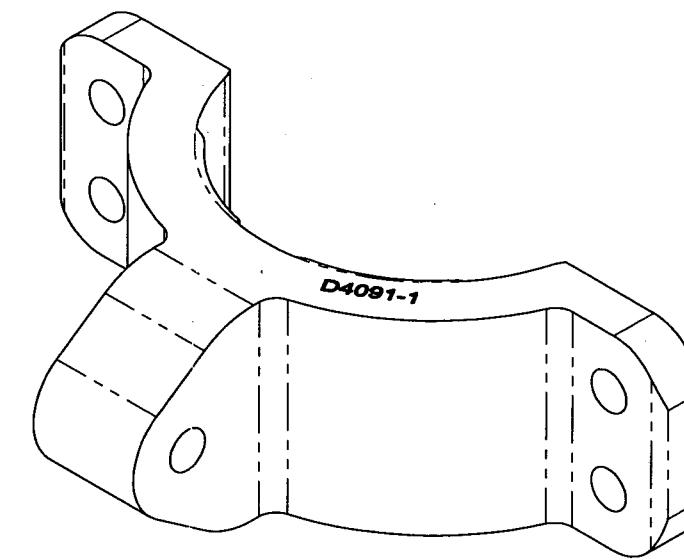
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C

C

B

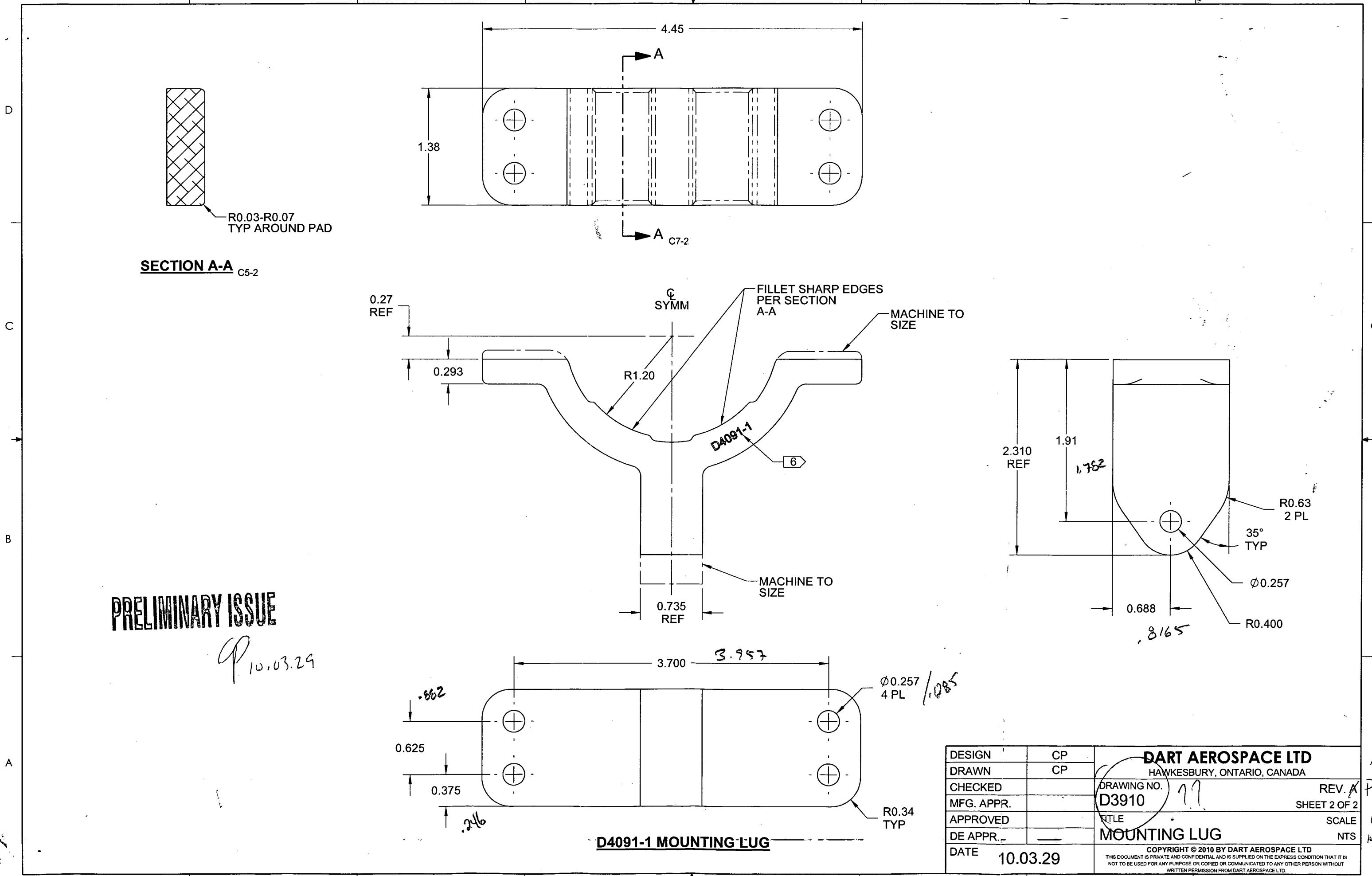
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**D4091-1 MOUNTING LUG****PRELIMINARY ISSUE***P
10.03.29***NOTES:**

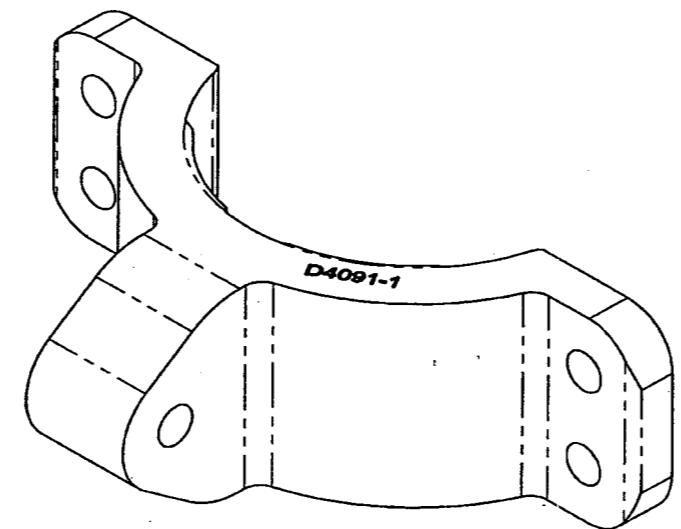
- 1) MATERIAL: MAKE FROM D2423 EXTRUSION
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: ENGRAVE PART NUMBER TO A DEPTH OF 0.010 ± 0.005 IN THIS LOCATION WITH A TOOL TIP RADIUS
OF 0.015 ± 0.005
- 7) WEIGHT: 0.31 lbs

P A NEW ISSUE		CP	10.03.29
REV.		DESCRIPTION	
DESIGN	CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	CP	DRAWING NO.	
CHECKED		REV. A	
MFG. APPR.		D3910	SHEET 1 OF 2
APPROVED		TITLE	
DE APPR.	—	SCALE	
DATE	10.03.29	NTS	

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8 7 6 5 4 3 2 1



D4091-1 MOUNTING LUG

W/ 57250

RELEASED
2010-04-29
[Handwritten signature]

- NOTES:
- 1) MATERIAL: MAKE FROM D2423 EXTRUSION
 - 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
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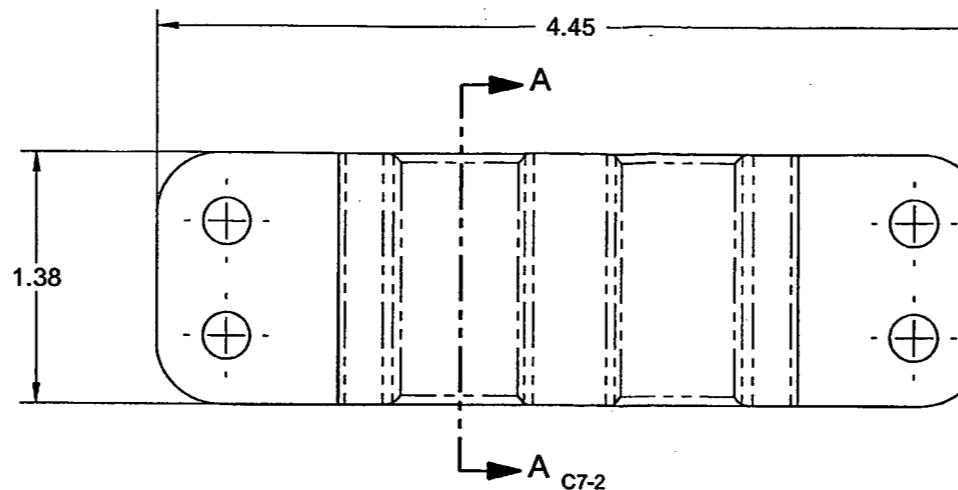
A	NEW ISSUE		CP	10.03.29
REV.	DESCRIPTION		BY	DATE
DESIGN	CP		DART AEROSPACE LTD	
DRAWN	CP		HAWKESBURY, ONTARIO, CANADA	
CHECKED			DRAWING NO.	
MFG. APPR.			D4091	REV. A
APPROVED				SHEET 1 OF 2
DE APPR.			TITLE	SCALE
			MOUNTING LUG	NTS
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8 7 6 5 4 3 2 1

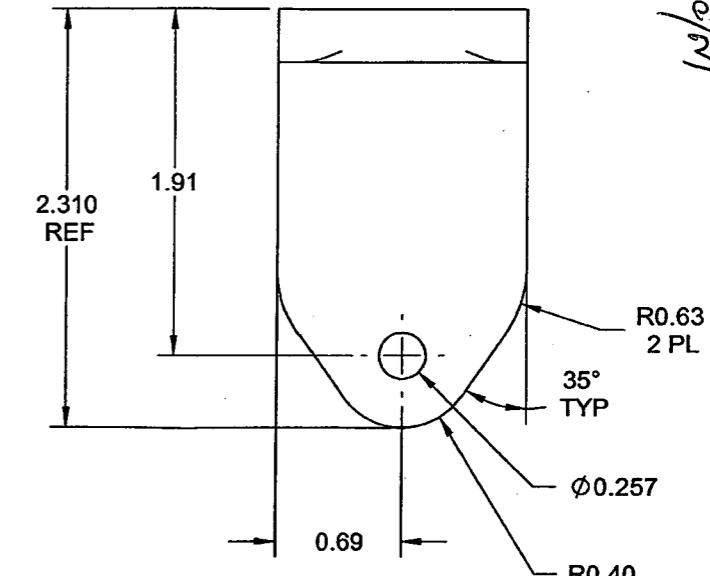
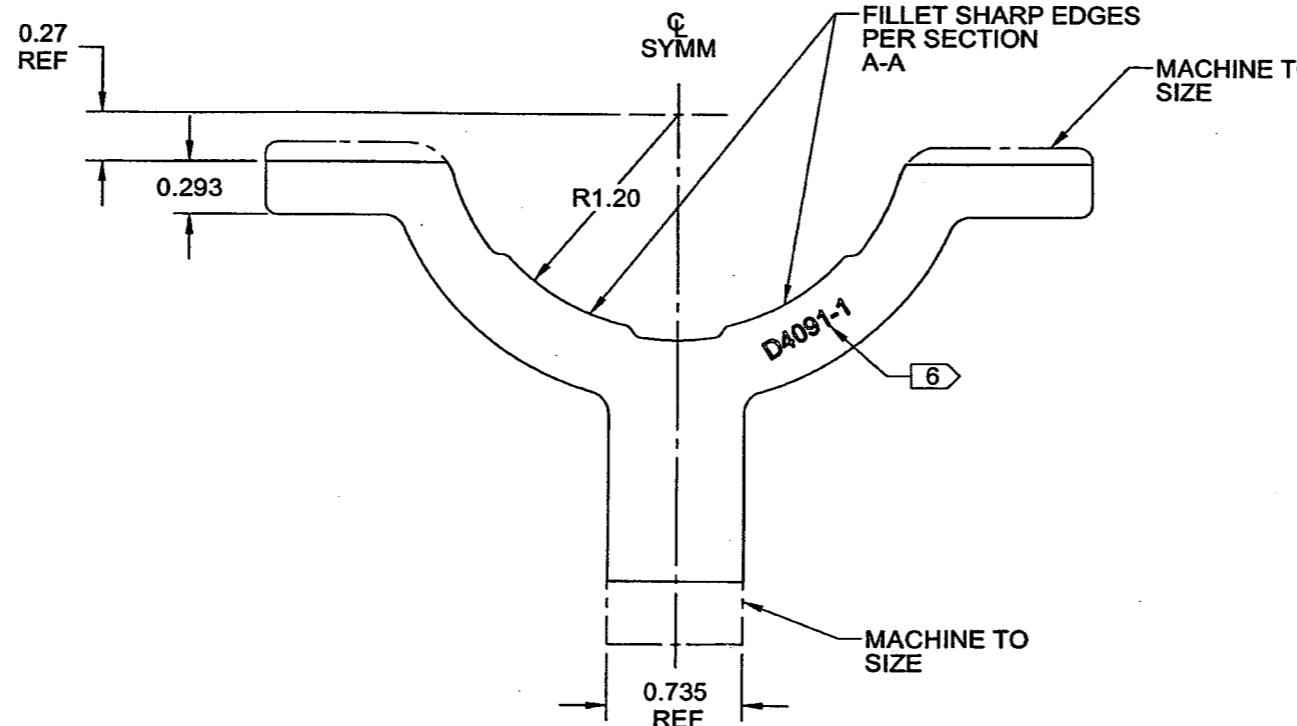
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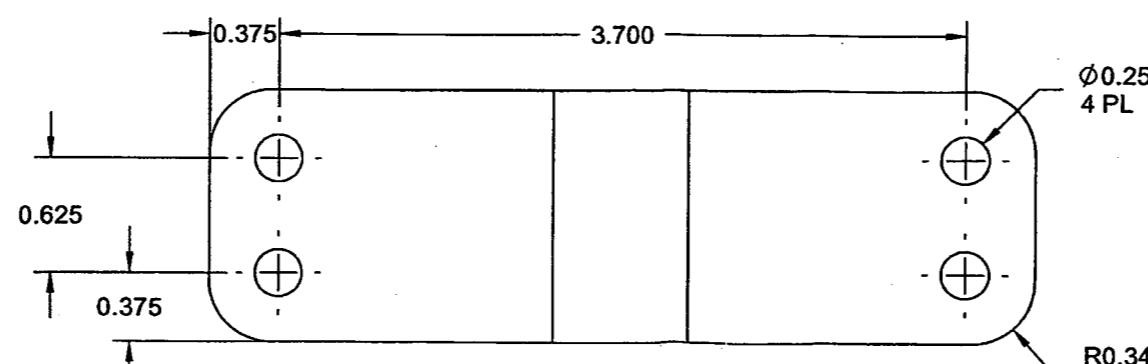
R0.03-R0.07
TYP AROUND PAD



SECTION A-A C5-2



w/o 57250



D4091-1 MOUNTING LUG

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2010-04-20
[Handwritten signatures]

DESIGN	OP	DART AEROSPACE LTD
DRAWN	OP	HAWKESBURY, ONTARIO, CANADA
CHECKED		DRAWING NO.
MFG. APPR.		D4091
APPROVED		REV. A
DE APPR.		SHEET 2 OF 2
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